

Work Order ID 91986

October-18-12 4:17:23 PM

91986

Page 1

Item ID: D4697-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lanyard Assembly

Start Date: 18/10/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 01/11/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: HLJ

Date: 12-10-19

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4697

A

100

0.00

100

Small Fab

Memo

0.00

Small Fab

1- CUT CABLE TO LENGTH AS PER DWG

2- REMOVE PROTECTIVE SLEEVE ON EACH END OF CABLE AS PER DWG

3- ASSEMBLE ADAPTER AND LOOP SLEEVE AS PER DWG (SEE NOTE 9)

4 0 FF
12-10-31

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

DAS
15
12-11-01

4

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Doc/Data <input type="checkbox"/>											
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Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

Identify as per dwg & Stock Location *077*

0.00

120

Packaging

Memo

116

0.00

Packaging

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/11/12 (4)

12/11/15

MCS 12-11-02

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

October-18-12 4:17:27 PM

Page 1

Work Order ID: 91986

91986

Parent Item: D4697-041

D4697-041

Parent Item Name: Lanyard Assembly

Start Date: 18/10/2012

Required Date: 01/11/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.10.02 PER DWG REVA DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
CBL-1240		Purchased	No				f	1,053.580		2.273684			

CBL-1240

Cable

**

FF 12-10-31

Location	Loc Qty	Loc Code
GA	1053.580041	
113565	3.911789	
119021	36.634852	
119690	13.0334	
122190	500	
123283	500	

2.2736

CBL-460

Purchased

No

Each

356.0000

8

CBL-460

Loop Sleeve

**

FF 12-10-31

Location	Loc Qty	Loc Code
GA	356	
121574	156	
123283	200	

8

D4697-1

Manufactured

No

Each

0.0000

4

D4697-1

Lanyard Adapter

**

FF 12-10-31

B 92186

4

NCR: Yes / No

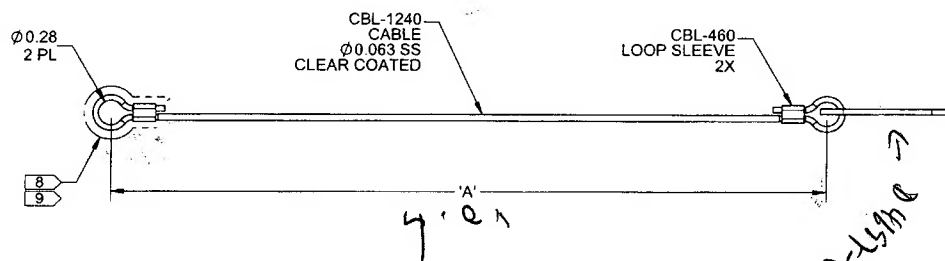
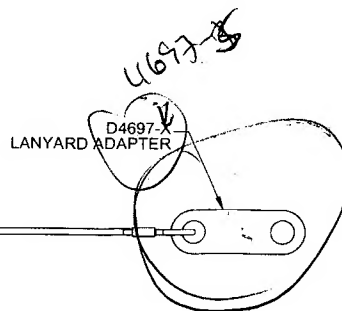
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ITEM	QTY -XXX	P/N	DESCRIPTION
	X	D4697-XXX	LANYARD ASSY
1	1	D4697-X	LANYARD ADAPTER
2	2	CBL-460	LOOP SLEEVE
3	A/R	CBL-1240	CABLE



D4697-XXX LANYARD ASSY

Note needs to be changed to 2.750

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY SHOWING DART P/N "D4697-XXX" AND BATCH NUMBER "BXXXXX" PER DART QSI 044 METHOD 6.7
- 7) WEIGHT: LESS THAN 0.01 lbs
- 8) REMOVE PROTECTIVE SLEEVE ALONG EXPOSED LENGTH (2.12 MIN - 2.25 MAX) EACH END
- 9) CUT CABLE 2.50" LONGER THAN DIM 'A'. FOLD ENDS TIGHT TO DIM 'A' LENGTH AND CRIMP SLEEVES USING CLB-705 CRIMP TOOL. ADDITIONAL LENGTHS MAY BE NECESSARY IN SOME APPLICATIONS. CUT AS REQUIRED. IN SOME CASES, OPEN END MAY REQUIRE CRIMPING AFTER ASSEMBLY WITH ATTACHING PARTS.

SHOP COPY
RETURN TO
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WORK COPY
NO. 91986 MLJ
12-10-19

DART P/N	DIM 'A'	D4697-X
D4697-041	4.0	-1
D4697-043	6.0	-1
D4697-045	8.0	-1
D4697-141	4.0	-3
D4697-143	6.0	-3
D4697-145	8.0	-3
D4697-241	4.0	-5
D4697-243	6.0	-5
D4697-245	8.0	-5

RELEASED
2012-09-26
MP

A	NEW ISSUE	RP	12.08.09
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	AS	D4697	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	LANYARD ASSY	NTS
DATE	12.08.09	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

NCR: Yes / No

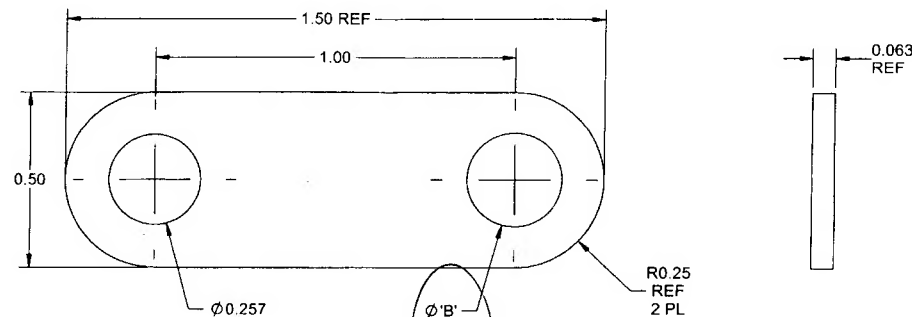
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91986



D4697-X LANYARD ADAPTER

DART P/N	DIM 'B'	FASTENER SIZE
D4697-1	0.266	1/4"
D4697-3	0.201	#10
D4697-5	0.177	#8

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240.
REF DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY SHOWING DART P/N "D4697-X" AND BATCH NUMBER "BXXXXX" PER DART QSI 044 METHOD 6.7
- 7) WEIGHT: LESS THAN 0.01 lbs

RELEASED
2012-09-26

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.	[Signature]	D4697	SHEET 2 OF 2
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	LANYARD ASSY	NTS
DATE	12.08.09	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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